

Split - 1

Page 1

[illegible]

Work Order ID 114667

114667

Page 2

March-11-14 2:53:37 PM

Item ID: D4653-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fitting Assembly
 Start Date: 12/03/2014 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 12/03/2014 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						(12) 14-06-25	DAS 9 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12		7614626	
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							DAS 30 9-89 12 14/06/27

March-11-14 2:53:37 PM

114667

Page 3

Item ID: D4653-045

Accept

N900040100

Setup Start *NIS1*

Revision ID:

Item Name: Fitting Assembly

Stop *NS2*

Start Date: 12/03/2014 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 12/03/2014 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

170

0.00

170

0.00

Small Fab

Memo

INSTALL O-RING AS PER DWG

Small Fab

180

QC5- Inspect part completeness to step on W/O

0.00

180

0.00

QC

Memo

Quality Control

120

Identify as per dwg & Stock Location: G.A.

0.00

190

0.00

Packaging

Packaging

Work Order ID 114667

114667

Page 4

March 11-14 2:53:37 PM

Item ID: D4653-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fitting Assembly
 Start Date: 12/03/2014 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 12/03/2014 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC21- Final Inspection - Work Order Release

0.00

2000

QC

Memo

0.00

Quality Control

ULS 14-06-26

MF
14-6-26

Picklist Print

Page 146

March-11-14 2:53:26 PM

Work Order ID: 114667

114667

Parent Item: D4653-045

D4653-045

Parent Item Name: Fitting Assembly

Start Date: 12/03/2014

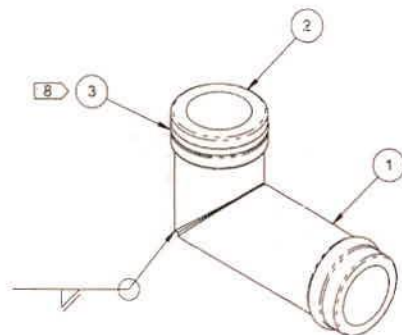
Required Date: 12/03/2014

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 12.06.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4654-3		Manufactured	No				Each	108.0000		24			
D4654-3									**			FF 14-06-26	
O-Ring													
					<u>Location</u>			<u>Loc Qty</u>					
					ST118			108					
					91370			74		12			
					93068			34					
D4653-7		Manufactured	No			110	Each	0.0000	1	24			
D4653-7									**			EL 14-6-23	
Fitting, Large					119019x20								
D4653-9		Manufactured	No			110	Each	20.0000	1	24			
D4653-9					117664x8				**			EL 14-6-23	
Fitting, Small													
					<u>Location</u>			<u>Loc Qty</u>					
					WA001			20					
					111452			20					
					117665x13								
					115923x11								



D4653-045 FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) WELD PER QSI 004
- 9) CHEMICAL CONVERSION COAT PRIOR TO INSTALLING O-RING

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4653-045	FITTING ASSEMBLY
1	1	D4653-7	LARGE FITTING
2	1	D4653-9	SMALL FITTING
3	1	D4654-3	O-RING

114667 MJS
140312

RELEASED
2012-11-05
MP

DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D4653	SHEET 2 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR	JE	VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. ANY DISSEMINATION OR THE EXPRESS CONSENT OF DART IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	